

# Aero Design Ltd.

## Work Order Control Sheet

Work Order#: 2016-124 Date Opened: 20-Sept-16 Title: Fabrication

Aircraft OEM: Bell Aircraft Model: 429 Product Type: Cargo Basket Product Model: Std Body/Lid Quantity: 2 RH

### Work Order Contents

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
N/A
N/A
N/A

### Build Sheet Contents

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC

### Drawing List

Drawing #	Rev #	Description	Initial or N/A
95951	0	Basket Body Fabrication	JC
95912	1	Lid Fabrication	JC
95964	0	Forward Attach Hoop	JC
95926	1	Aft Attach Hoop	JC
95925	1	Forward Attach Hoop	JC
94520	0	Hoop	JC
84262	2	Basket Handle Provisions	JC
84263	0	Lid Handle Provisions	JC

### Traveller

Initial or N/A


### Component Completion

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1 / 1
N/A
1 / 1
N/A

### Certification

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
N/A
N/A

### Additional Documentation

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

### Billing

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

### Notes

Work performed by:  
ICC / Dual Inspection performed by:  
Work Order closed by:  
Form 20.D.03

Print: Andrew Bartfai  
Print: Jason Rekve  
Print: Jeff Clarke  
Rev. Original 23 Sep 2014

Sign: [Signature]  
Sign: [Signature]  
Sign: [Signature]

SCA: AD07  
SCA: AD01  
SCA: AD02

Date: 27-Sep-16  
Date: 28 Oct 16  
Date: 08 May 17

Work Order: 2016-124  
 Date Opened: Sept 2016

Material Tracking Sheet  
 Bell 429 - Post 81  
 Hoops Fabrication

1 of 2

X 2 R/H

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	6		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 1	2		94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	2015-25
Step 2		84262		Welding		
	2		84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
	A/R		--	Welding Rod	ER70S-2	14005
Step 3				Inspection	None	
	2		95964-01-01	Hoop - attachment (forward) (-01 RH, -02 LH)		
Step 1				Fabrication		
	1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	2016-41
Step 2				Welding		
	1		95925-02	Lug	1018 Steel, 5/8" Rod	15039 08-2013-11
	1		95925-03	Lug	1018 Steel, 5/8" Rod	15039 08-2013-11
	A/R		--	Welding Rod	ER70S-2	14005
Step 3				Inspection and Finishing	None	

Work Order: 2016-124  
 Date Opened: Sept. - 2016

Material Tracking Sheet  
 Bell 429 - Post 81  
 Hoops Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>2</u>		95926-01	Hoop - attachment (aft)		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	<u>14076</u>
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 1		95926-04	Lug	1018 Mild Steel, 5/8" Dia.	<u>2013-14</u>
	. 1		95926-05	Lug	1018 Mild Steel, 5/8" Dia.	<u>2013-14</u>
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	<u>15024</u>
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	<u>15035</u>
	. A/R		--	Welding Rod	ER70S-2	<u>14005</u>
Step 9				Finishing and Inspection	None	





## Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 Hop Handle No. of pieces: 1

Manufacturer: \_\_\_\_\_

Part No.: 94520-01 Serial / Batch No.: \_\_\_\_\_

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2015<sup>re</sup> 25

Remaining Tasks to be Performed: weld into basket

Signature: K. Craven

Date: March 10, 2015 Lic. No. / SCA \_\_\_\_\_

In Process



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AMF 73-04

### Remarks

**In Process**

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2016-124

X 2

R/H

## **CARGO BASKET LID FABRICATION - COMMON**

Sept. 2016

### **General**

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90612, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95912, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82812, Revision 0 – Standard Basket

### **Options**

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

## CARGO BASKET LID FABRICATION

Complete  
(initial or SCA #)

Work Order: 2016-124

Date Open: Sept. 2016

1. Rim Assembly – Basket Lid

- a. Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
  - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

AD	AD
73-04	73-04
<u>01</u>	<u>01</u>

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

AD	AD
73-04	73-04
<u>05</u>	<u>05</u>

3. Inspection

- a. Rim for complete welds

AD	AD
73-04	73-04
<u>05</u>	<u>05</u>

4. Frame assembly – Lid

- a. General
  - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit  $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AD	AD
73-04	73-04
<u>05</u>	<u>05</u>

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut  $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD	AD
73-04	73-04
<u>05</u>	<u>05</u>

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

AD	AD
73-04	73-04
<u>05</u>	<u>05</u>

7. Inspection

- a. Frame assembly for complete welds.

AD	AD
73-04	73-04
<u>05</u>	<u>05</u>



## CARGO BASKET LID FABRICATION

Complete

(initial or SCA #)

N/A N/A

### 8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

### 9. Weld mesh to frame assembly per drawing.

N/A N/A

- General welding requirements for all lids:
  - Every intersection on all edges.
  - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
  - $\frac{3}{4}$ " for lids under 76"
  - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

AD  
73-04  
05

AD  
73-04  
05

### 10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
  - Standard location:  $\frac{1}{4}$ " outside of last cross member on both ends.
  - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
  - one or two in accordance with drawing.
  - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
  - Locate on cross member to set bracket in centre bay of lid.
  - Record placard bracket WO and welding rod PO on attached material list.

AD  
73-04  
01

AD  
73-04  
01

### 11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using  $\frac{1}{4}$ " (#3) centre drill.
  - 3 places for lids under 76"
  - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

AD  
73-04  
01

AD  
73-04  
01

### 12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).



## CARGO BASKET LID FABRICATION

Complete

(initial or SCA #)

### 13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

PO	PO
73-04	73-04
02	02

2016-124 X 2 R/H

Sept. 2016

## **CARGO BASKET BODY FABRICATION - COMMON**

### **General**

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

*Options* 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355 – left or right**

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

*Options* 70406, Revision 2 – Front end cutout – 764/776/784/940

#### **Robinson R44 – left or right**

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

*Options* 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

*Options* 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options – Applicable to all models**

70403, Revision 5 – Auxiliary Latch

# CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-124

Date Open: Sept. 2016

AD  
73-04  
007

AD  
73-04  
01

## 1. Rim Assembly – Basket Body

- Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD

73-04  
05

AD

73-04  
05

## 2. Weld Rim Assembly.

- Record welding rod PO on attached material list.
- 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD

73-04  
05

AD

73-04  
05

## 3. Inspection

- Rim for complete welds

AD

73-04  
05

AD

73-04  
05

## 4. Frame assembly – body

- General
  - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- Grind corner welds from step 2 on rim to allow hoops to sit flat.
- Pull required hoops from stock - standard, attachment, handle.
  - If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - Ensure vent hole is located at centre of tube to vent spine tubes.
- Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - Ensure correct order and orientation of hoops. Refer to drawing.
    - Attachment lugs are on inboard side.
    - Handle bracket bushings are on outboard side, second hoop from both ends.  
May be on attachment hoops.
  - Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - Refer to applicable drawing for position, not required on some baskets.
- Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.



## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

AD	AD
73-04	73-04
05	05

### 5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD	AD
73-04	73-04
05	05

### 6. Inspection

- a. Frame assembly for complete welds.

AD	AD
73-04	73-04
07	07

### 7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh 1/4" down at 60 degrees.
  - iv. Fit mesh to front end of basket.

## CARGO BASKET BODY FABRICATION - COMMON

Complete

(initial or SCA #)

### 8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
  - i. Every intersection at top edges.
  - ii. Every intersection at ends.
  - iii. First 5 intersections down on hoops, then every second intersection.
  - iv. Every intersection along spine.
  - v. Extra large baskets – every intersection along corner.
  - vi. Every intersection around ends
  - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

AD  
73-04  
05

AD  
73-04  
05

### 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

AD  
73-04  
05

AD  
73-04  
05

### 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD  
73-04  
07

AD  
73-04  
07

### 11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
  - i. Hoops for height.
  - ii. Rim for width and length and alignment.
  - iii. Lid prop lugs in correct ends.
  - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AD  
73-04  
01

AD  
73-04  
01



## CARGO BASKET BODY FABRICATION - COMMON

Complete

Initial or Signature

73-04

73-04

02

02

- e. Tag complete basket body assembly in preparation for powder coating.

### 12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2016-124  
 Date Opened: Sept-2016

Material Tracking Sheet  
 Bell 429 - Post 81  
 Basket Body Fabrication

1 of 2

X2 R/H

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	X2		95951-01-01	Basket Body Assembly	(-01 RH, -02 LH)	
Step 1				Rim Assembly		
	.2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
	.2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
	.1		--	3/4" Tube - Long stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
	.4		--	3/4" Tube - Short Rim (2.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
Step 2				Weld Rim Assembly		
	A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
	.3		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
	.1	84262	94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	+15072 X see attached
	.1		95964-01	Forward Attachment Hoop		+15072 X see attached
	.1		95926-01	Aft Attachment hoop - with handle provisions		+16037 X see attached
	.5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
	.1		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 5				Weld Frame Assembly		
	A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
Step 6				Inspection - Frame Assembly	None	
Step 7				Mesh Assembly		
	.1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	16009
	.1		--	Mesh (End - 24.75" x 16.75")	3/4-16F Expanded Mild Steel sheet	16038

Work Order: 2016-124  
 Date Opened: Sept. 2016

Material Tracking Sheet  
 Bell 429 - Post 81  
 Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
<b>Step 8</b>				<i>Weld Mesh</i>		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	15090
<b>Step 9</b>				<i>Weld Basket Components</i>		
Step 9.a.	1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 9.b.	1		--	Cap	1018 Mild Steel, 0.032" Sheet	2019
	A/R			Welding Rod	ER70S-2 TIG Rod	14005
Step 9.d.	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2014-18
	A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				<i>Powder Coating</i>		16068/16073



Work Order: 2016-124  
 Date Opened: Sept. 2016

Material Tracking Sheet  
 Bell 429 - Post 81  
 Lid Fabrication

X2 R/H

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	X2		95912-01	Lid Assembly		
Step 1				Rim Assembly		
	. 2		--	3/4" Tube - Long Rim (97.0")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123/15072
Step 2				Weld Rim Assembly		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	15072
Step 5	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 6				Weld Frame Assembly		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
Step 7				Inspection - Frame Assembly	None	
Step 10				Weld Lid Components		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		2016-54
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R		--	Welding Rod	ER308L TIG Rod	14028
	. 1		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	14028

Work Order: 2016-124

Date Opened: Sept. 2016

Material Tracking Sheet  
Bell 429 - Post 81  
Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 11				Clean Up		
Step 12				Inspection - Final Assembly		
Step 13				Powder Coating		16068 / 16073



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BACKARD BLADE SET No. of pieces: 50

Manufacturer: AERO DESIGN

Part No.: 56204-10 Serial / Batch No.: \_\_\_\_\_

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-18

Remaining Tasks to be Performed: weld CORNER / in A202

corner welded AD-C5/

Signature: [Signature]

Date: FEB 18, 2014 Lic. No. / ACA A006

In Process





## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (B429) No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 95951-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-124

Remaining Tasks to be Performed: CLEAN UP, INSPECT, POWDER COAT  
✓ ✓ ✓

Signature: [Signature]

Date: 27 SEPT 2016 Lic. No. / SCA ADO2

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LID (B429) No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 95912-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-124

Remaining Tasks to be Performed: CLEAN UP, INSPECT, POWDER COAT  
✓ ✓ ✓

Signature: [Signature] Chh.

Date: 27 SEPT 2016 Lic. No. / SCA AD002

In Process





## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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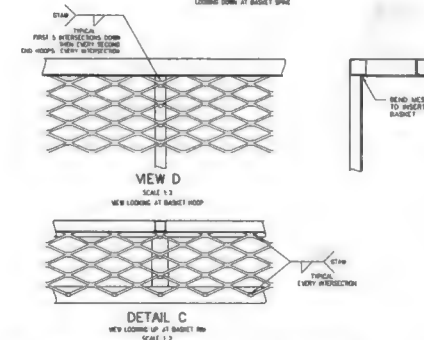
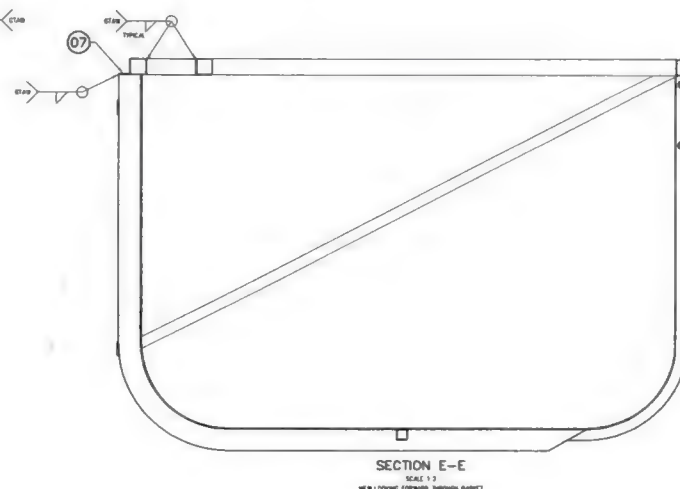
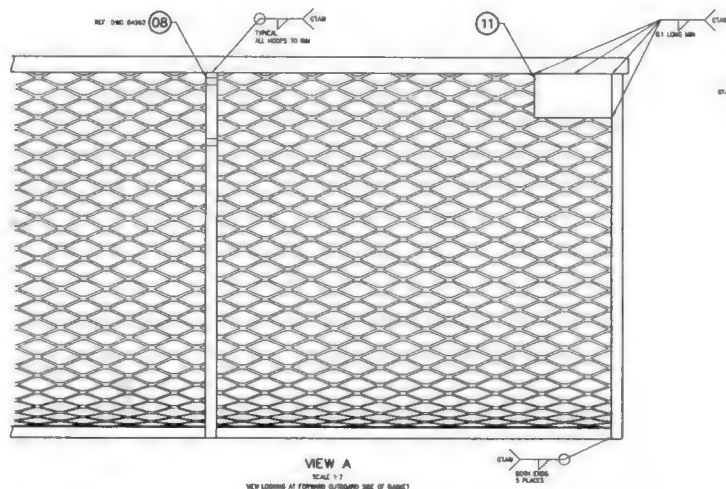
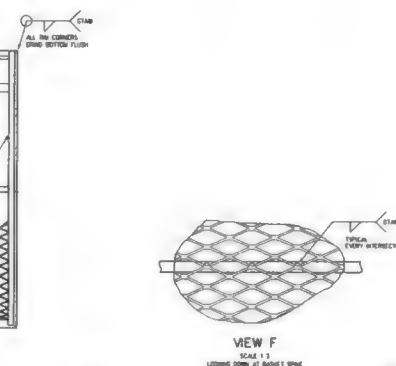
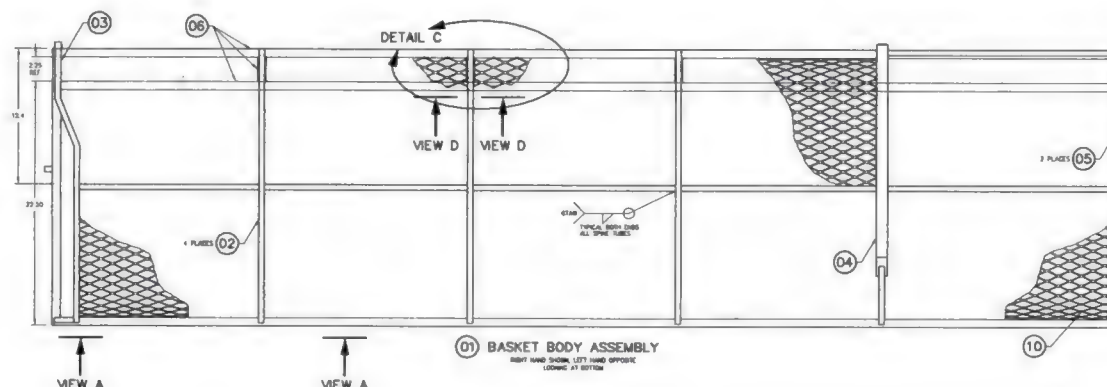
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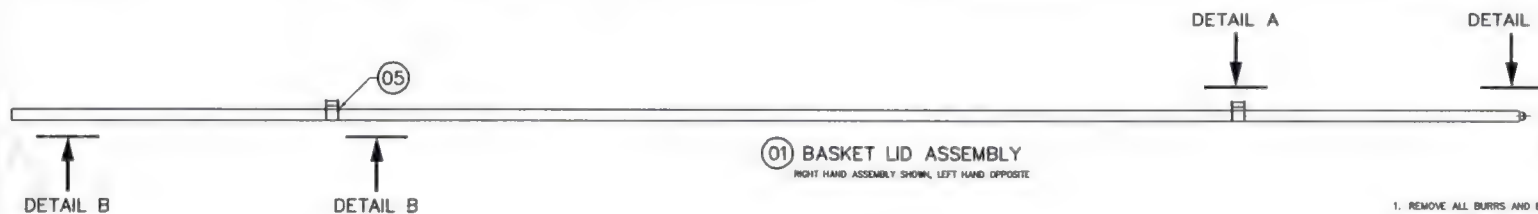
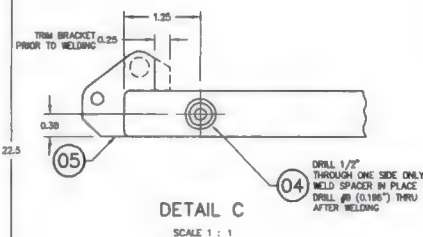
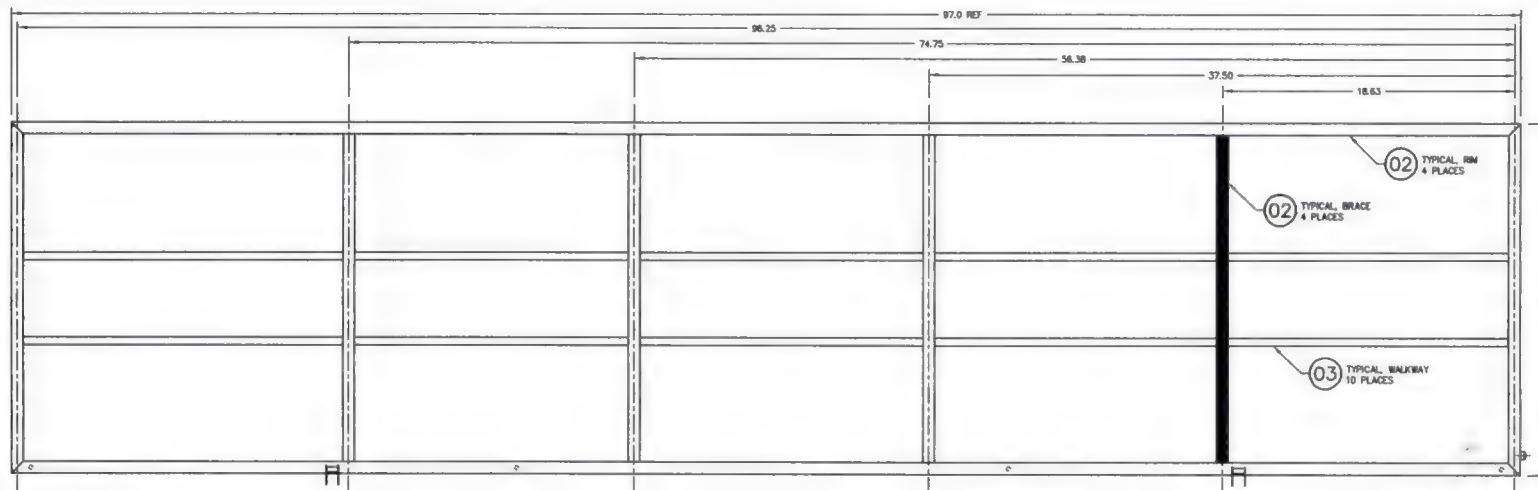
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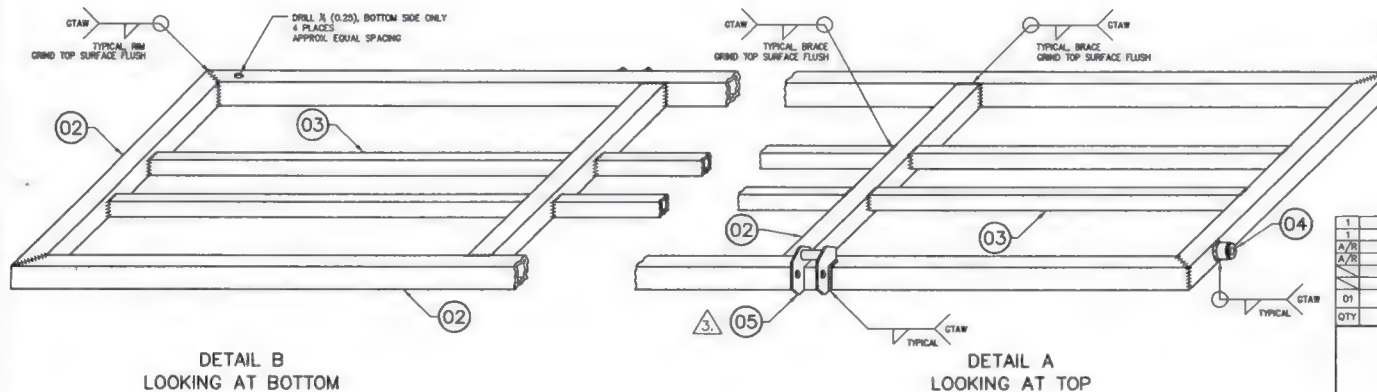
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 8838C  
4130 AND 1018 STEEL. WELDING ROD SHALL CONFORM TO E70S-2 OR EQUIVALENT  
STAINLESS STEEL AND 4130 WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
3. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED NUT HOLES WITH ROSETTE WELD
4. THOROUGHLY CLEAN AND POWDER COAT ROCKET SUB-ASSEMBLY PRIOR TO ASSEMBLY

[illegible]

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE - CREATED FROM 84612		
1	TITLE BLOCK UPDATED; WELDING NOTES; HANDLE PROV. P/N; BUMPER HOLES	BJC	20/02/2014



01 BASKET LID ASSEMBLY  
RIGHT HAND ASSEMBLY SHOWN, LEFT HAND OPPOSITE



1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2685C.  
4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.  
STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84283
4. TYP 2 PLACES. NOTE BRACKET MODIFICATION SHOWN IN DETAIL C.
5. VENT 0.5" TUBES BY DRILLING #50 HOLE INTO 0.75" TUBES WHERE IT WILL BE COVERED BY THE 0.5" TUBE.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

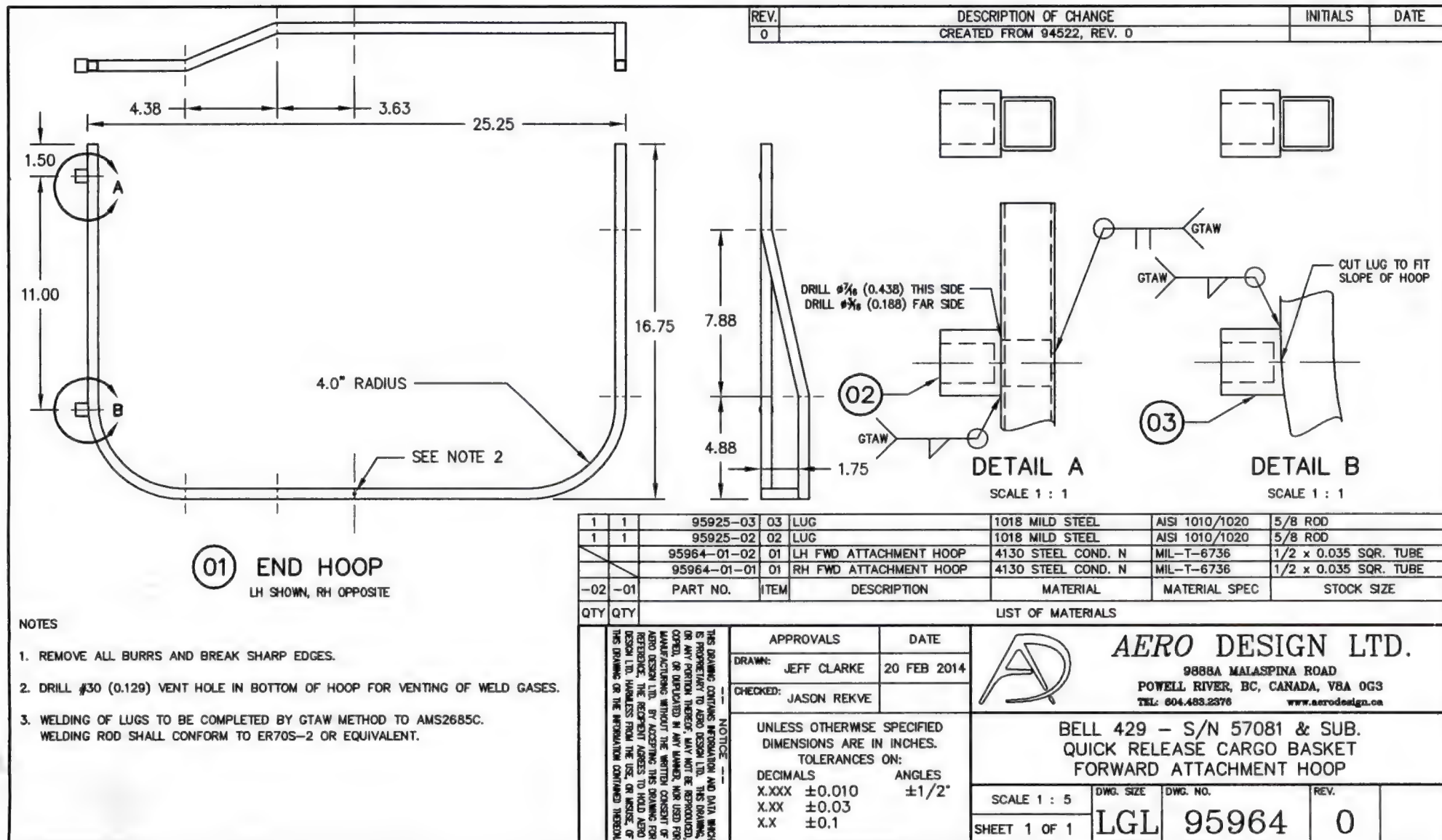
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
1	49216-01	04	SPACER			
A/R	--	03	TUBE	4130 STEEL, COND. N	ML-T-8738	0.5 X 0.035 SQR. TUBE
A/R	--	02	TUBE	4130 STEEL, COND. N	ML-T-8738	0.75 X 0.035 SQR. TUBE
	95912-01-02	01	LH BASKET LID ASSEMBLY			
	95912-01-01	01	RH BASKET LID ASSEMBLY			
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY						
LIST OF MATERIALS						
			APPROVALS	DATE		
			DRAWN: JEFF CLARKE	11 SEPT 2012		
			CHECKED: E. BURCOON	10 NOV 2012		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
			DECIMALS ANGLES			
			X.XXX ±0.010 ±1/2"			
			X.XX ±0.03			
			X.X ±0.1			
			SCALE 1 : 4			
			SHEET 1 OF 1			
			A1 95912 1			

		<b>AERO DESIGN LTD.</b>	
PO BOX 1457, ST. CATHARINES, ONT. L7M 7A5		TEL: 905.466.1276	
FAX: 905.466.1276		www.aerodesign.ca	
BELL 429			
QUICK RELEASE CARGO BASKET			
BASKET LID ASSEMBLY			
DWG. NO.	DWG. NO.	DWG. NO.	REV.
A1	95912		1



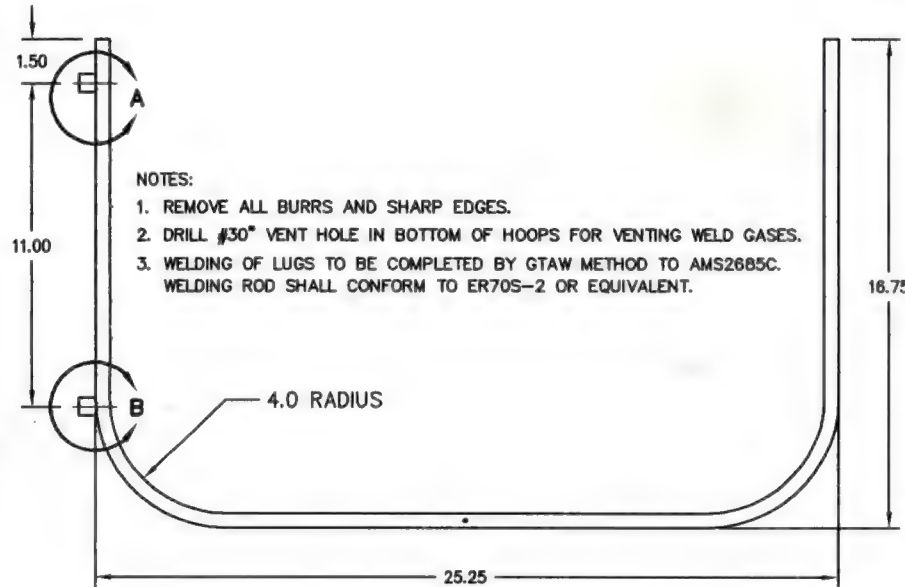
**AERO DESIGN LTD.**  
8686A MALASPINA ROAD  
POWELL RIVER, B.C. CANADA V8A 0G3  
TEL: 604.483.9770 www.aerodesign.ca

BELL 429  
QUICK RELEASE CARGO BASKET  
BASKET LID ASSEMBLY

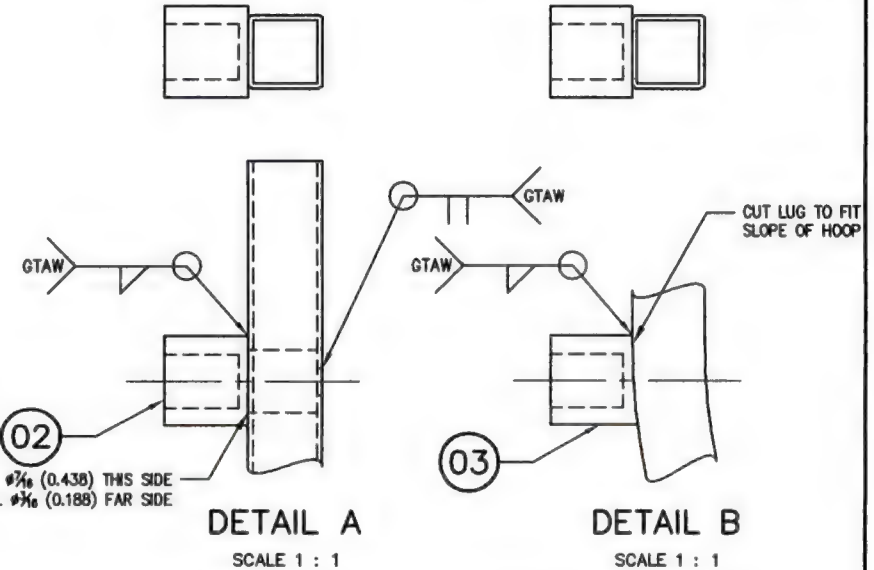
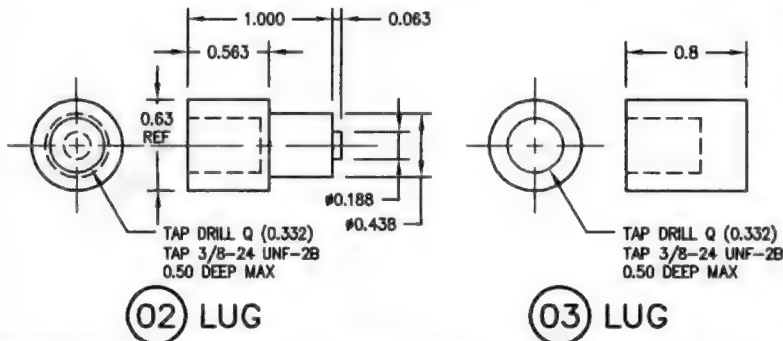




REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			
1	TITLE BLOCK UPDATED	BJC	20/02/2014



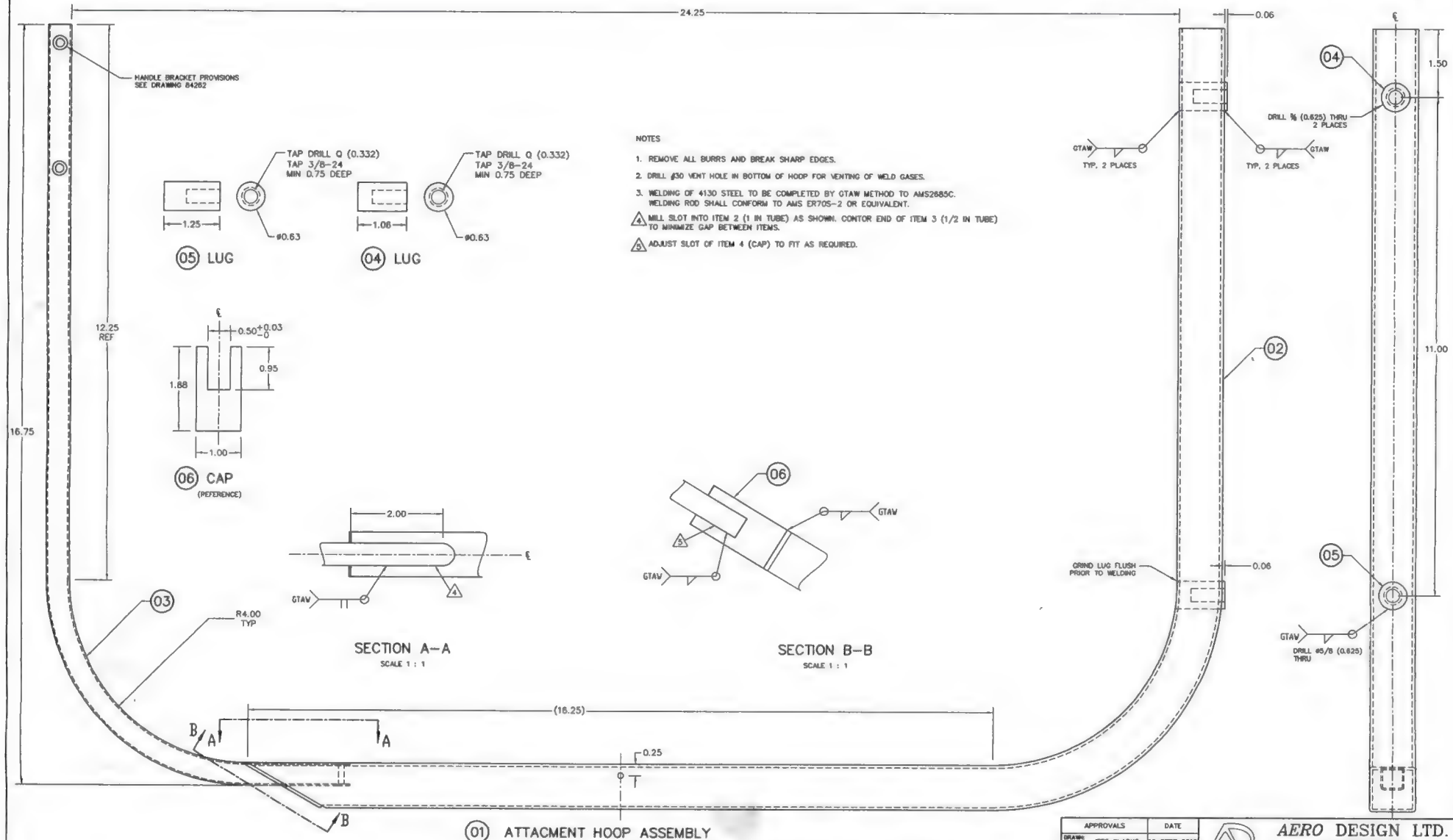
**01 FORWARD HOOP**



QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95925-03	03	LUG	1018 MILD STEEL	AIISI 1010/1020	5/8 ROD
1	95925-02	02	LUG	1018 MILD STEEL	AIISI 1010/1020	5/8 ROD
1	95925-01	01	FORWARD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

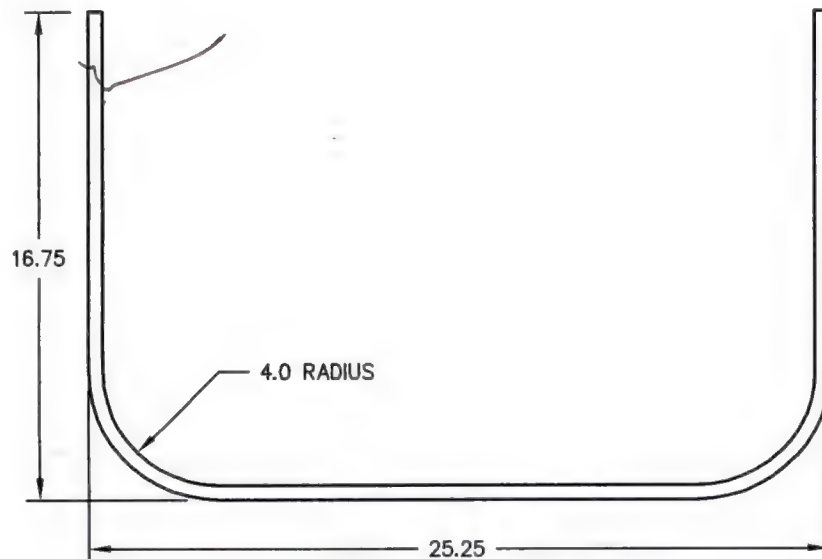
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	<p>UNLESS OTHERWISE SPECIFIED</p> <p>DIMENSIONS ARE IN INCHES.</p> <p>TOLERANCES ON:</p> <p>DECIMALS ANGLES</p> <p>X.XXX ±0.010 ±1/2°</p> <p>X.XX ±0.03</p> <p>X.X ±0.1</p>		
	<p>BELL 429 - S/N 57001 THRU 57080</p> <p>QUICK RELEASE CARGO BASKET</p> <p>FORWARD ATTACHMENT HOOP</p>		
	<p>SCALE 1:5</p> <p>SHEET 1 OF 1</p>	<p>DWG. SIZE</p> <p>LGL</p>	

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; HANDLE PROVISIONS ADDED	BJC	20 FEB 2014



PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
01	01	ATTACHMENT HOOP ASSEMBLY	4130 STEEL COND. II	MIL-T-8736	1 X 0.085 SOR TUBE
02	02	TUBE 1IN	4130 STEEL COND. II	MIL-T-8736	1 X 0.085 SOR TUBE
03	03	HANDLE BRACKET PROVISIONS	1018 MILD STEEL	ASS 1010/1020	0.032-0.050 SHEET
04	04	LUG	1018 MILD STEEL	ASS 1010/1020	5/8 DIA ROD
05	05	LUG	1018 MILD STEEL	ASS 1010/1020	5/8 DIA ROD
06	06	CAP	1018 MILD STEEL	ASS 1010/1020	5/8 DIA ROD

APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: JEFF CLARKE	12 SEPT 2012	9806A MALASPITA ROAD	
CHECKED: E. BURCOM	10 NOV 2012	POWELL RIVER, BC, CANADA. V8A 0G5	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.		BELL 429	
TOLERANCES ON:		QUICK RELEASE CARGO BASKET ATTACHMENT HOOP FABRICATION	
DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			
SCALE 1:1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	95926	1



① HOOP

NOTES:

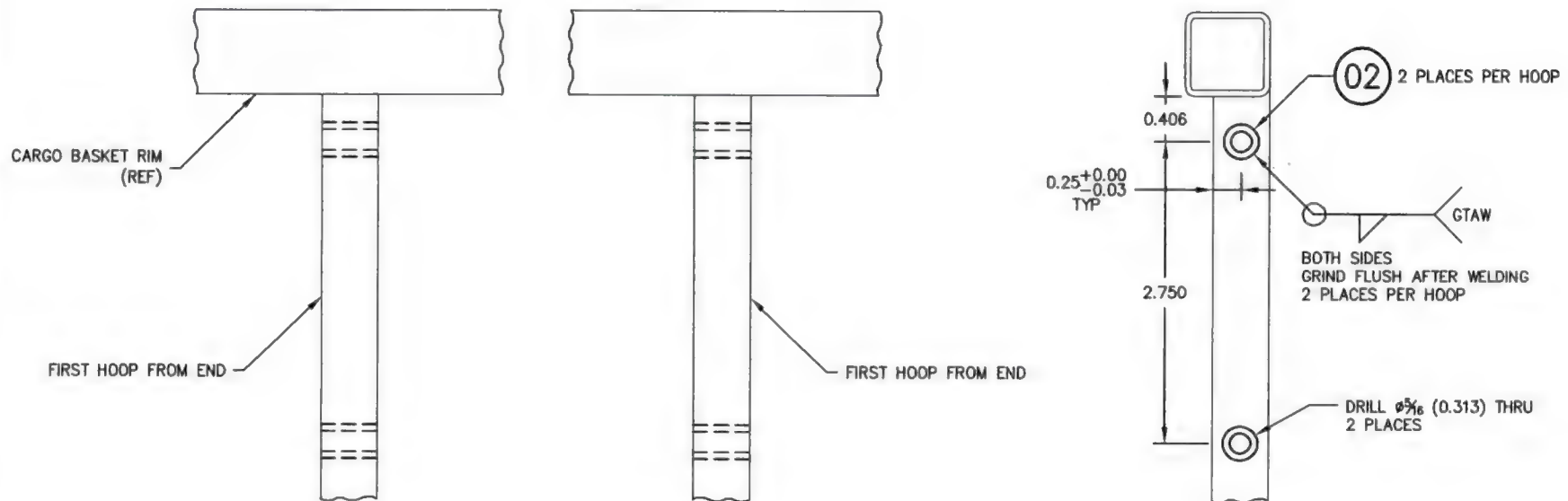
1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

94520-01		01	END HOOP	4130 STEEL COND. N		MIL-T-6736	1/2 x 0.035 SQR. TUBE	
01	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY		LIST OF MATERIALS						
<div>NOTICE</div> <div>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECEPT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</div>		APPROVALS		DATE		<div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca</div>		
		DRAWN: JEFF CLARKE		13 SEPT 2011				
		CHECKED: E. BURGOIN				<div>BELL 206L SERIES, 407</div> <div>QUICK RELEASE CARGO BASKET</div> <div>HOOP</div>		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:						
DECIMALS		ANGLES		SCALE 1 : 5		DWG. SIZE	DWG. NO.	REV.
X.XXX ±0.010		±1/2"		SHEET 1 OF 1		LGL	94520	0
X.XX ±0.03								
X.X ±0.1								

APPROVALS	DATE
DRAWN: JEFF CLARKE	13 SEPT 2011
CHECKED: E. BURGAIN	
<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:</p> <p>DECIMALS ANGLES</p> <p>X.XXX ±0.010 ±1/2°</p> <p>X.XX ±0.03</p> <p>X.X ±0.1</p>	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE LID PROVISIONS TO 84263	BJC	14/02/2014



# **01 BASKET HANDLE PROVISIONS ASSEMBLY** PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

## NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY
01	PART NO.	ITEM	DESCRIPTION
QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

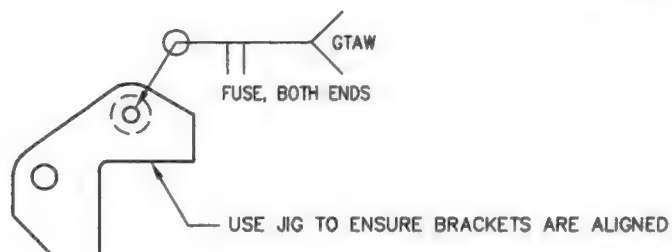
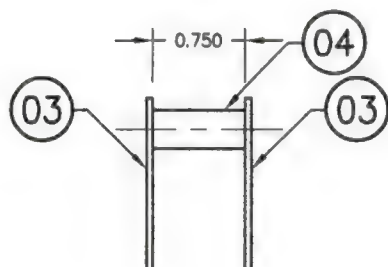
9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.463.8378 www.aerodesign.ca

HELICOPTER CARGO BASKET  
BASKET HANDLE PROVISIONS ASSEMBLY

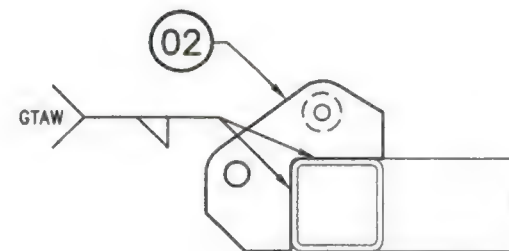
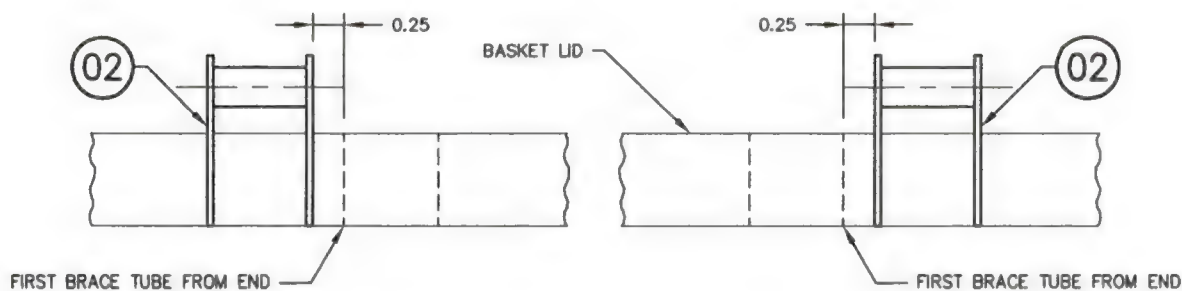
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 84262 REV. 1	BJC	14/02/2014



## 02 HANDLE BRACKET ASSEMBLY



## 01 LID HANDLE PROVISIONS ASSEMBLY

### NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275-02	04	SUPPORT
2		36273-01	03	LID BRACKET
	2	84263-02	02	HANDLE BRACKET ASSEMBLY
		84263-01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 FEB 2014
CHECKED: JASON REKVE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	

 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.683.8376 www.aerodesign.ca		<b>HELICOPTER CARGO BASKET LID HANDLE PROVISIONS ASSEMBLY</b>	
		SCALE 1 : 1	DWG. SIZE <b>A3</b> DWG. NO. <b>84263</b> REV. <b>0</b>
SHEET 1 OF 1			



# Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Hoop No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 95964-01/94522-01 Serial / Batch No.: 15072

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-41

Remaining Tasks to be Performed: Provisions to be machined

Signature: Don Baffi

Date: March 21st / 2016 Lic. No. / SCA AD-07

In Process



**Aero Design Ltd.**

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**Remarks**

**In Process**

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Remaining Tasks to be Performed: Provisions to be machined

Signature: Dan Butti

Date: March 21<sup>st</sup> / 2016 Lic. No. / SCA AD-07

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

Remarks

**In Process**

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